

Work Order ID 50515

July 13, 2009 10:39:55 AM



Page 1

Item ID: D2224

Accept



Setup Start



Revision ID: E

Stop



Item Name: Rappel Anchor

Start Date: 7/17/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 6.00



Customer:

Reference:

JUL 09-07-16

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2224	Rev E

100 0.00

BAND SAW

Bandsaw Memo 0.00

Jeaspa Bandsaw Cut blanks: 2.8" ***** Note grain direction *****

6 0

and 09/07/20

110 0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 I-Machine as per Folio D2224 & Dwg D2224 2-Deburr & Tumble

6 0

and 09/07/20

120 0.00

QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

6 0

and 09/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SK09/07/23

6 ✓

140



Outsource4

Outsource process-Anodize per QSI017 4.1.10.1

0.00

CL 09/08/07 6

Outsource process - Anodize

Memo

0.00

Issue P/O: 10180 Red Anodize as per Dwg D2224 MIL-A-8625

150



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Peg/8/17 (6)

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Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

=> SOR/48/18

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Picklist Print

July 13, 2009 10:39:54 AM

Page 1 / 1

Work Order ID: 50515



Parent Item: D2224RevE



Parent Item Name: Rappel Anchor

Start Date: 7/17/09

Required Date: 7/24/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	5.3300	1.3958			

7075-T73 Bar 2.50 x 3.25



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	5.33	(M107955)
102694	5.33	

MF
07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50515
Description: Rappel Anchor	Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

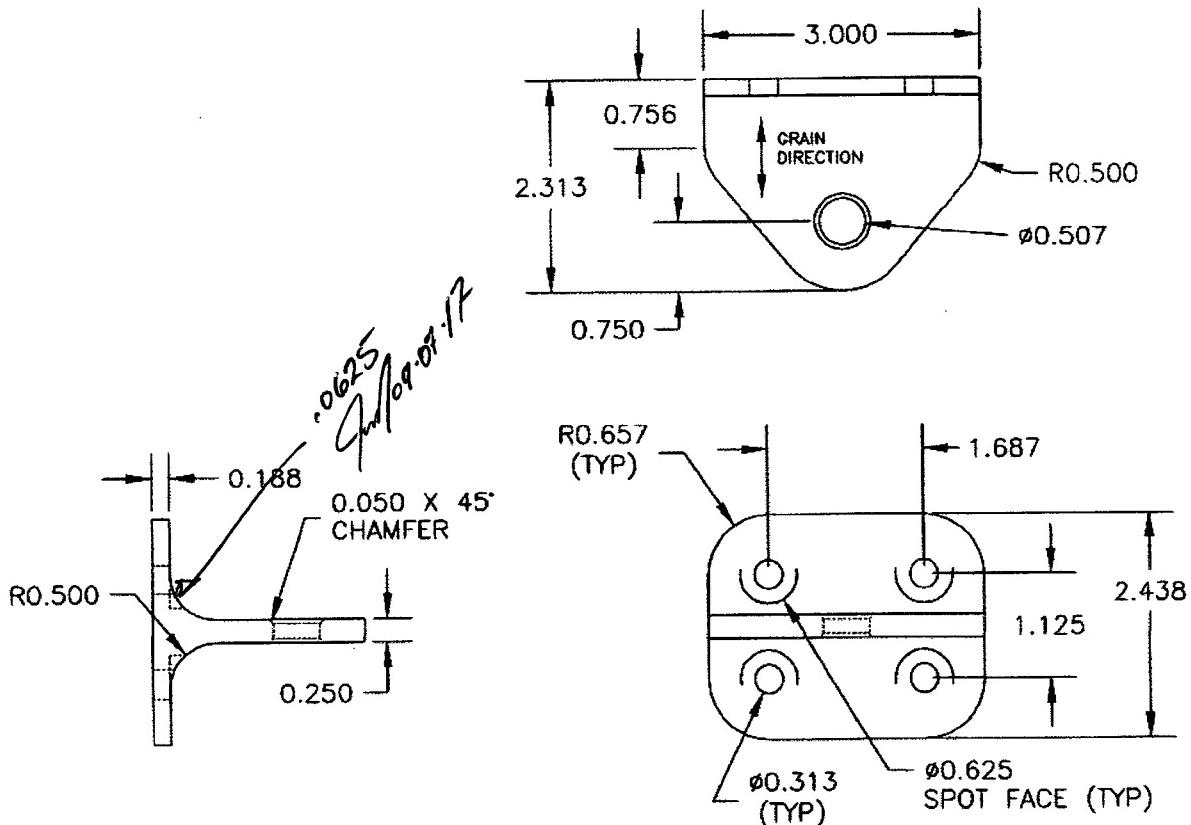
X First Article Prototype

Measured by:	<i>[Signature]</i>	Audited by:		Prototype Approval:	N/A
Date:	09/07/20	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	

DART

DESIGN	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
 99.09.11 KE


MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
 FINISH : ANODIZE RED PER MIL-A-8625
 BREAK ALL UNMARKED EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TNM***ANODISATION et PEINTURE TNM INC.***

C.OFC



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

76659

8/14/2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7**CERTIFICATE OF COMPLIANCE**
CERTIFICAT DE CONFORMITE**NO. DE COMMANDE:** 513966
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	16	16	D2224 B50813	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	6	6	D2224 B50515	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	30	30	D2224 B50878	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8/14/08/18

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

Part Aerospace
1270 Aberdeen St.
Hawkesbury Ont.
K6A - 1K7

N° DE COMMANDE - ORDER NO.	DÉP. - DEPT.	DATE
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO	
ADRESSE - ADDRESS	ADRESSE - ADDRESS	

09/08/07

Anodizing + Paint 21 Aviation RD
Painte - Class QC. H9R - 4Z2

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
	P.O. 10180			514-429-7777
16	D2224	B 50813		
4	D2224	B 50515		
30	D2224	B 50878 Red anodize as per		
		4 MIL-A-8625F type 1 an		
		1B / II / IC / II B class 2		
		Please ship back. pivotated cost \$ 7684382		
		Thanks Chantal.		
		CERTIFICATE OF CONFORMITY REQD UPON DELIVERY		
			TPS/GST	
			TVP/PST	
513966	SIGNATURE	N° LIC. - LIC. NO.	TOTAL	